

Work Order ID 47001B ✓

June 29, 2009 12:47:56 PM



Page 1

Item ID: D3186-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, LH

Start Date: 17/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *WF*

Date: 09-09-21 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3186	Rev D
-------	-------

100	0.00
-----	------

	Small Fab
--	-----------

Small Fab	Memo	0.00
-----------	------	------

Small Fab	1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)	
-----------	--	--

CT 09-07-21

110	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

	Memo	0.00
--	------	------

QC		
----	--	--

Quality Control		
-----------------	--	--

809108104

✓

120	Identify as per dwg & Stock Location:	0.00
-----	---------------------------------------	------

	Memo	0.00
--	------	------

Packaging		
-----------	--	--

Packaging		
-----------	--	--

PPP 50584

9/8/15 105

Work Order ID 47001B

June 29, 2009 12:47:56 PM



Page 2

Item ID: D3186-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, LH

Start Date: 17/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

MF 09-08-06
J080812

10f
Picklist Print

June 29, 2009 12:47:55 PM

Page 1

Work Order ID: 47001B



Parent Item: D3186-3RevD



Parent Item Name: Spacepod Door. LH

Start Date: 17/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-1MRevD		Manufactured		No			Each	0.0000	1.0000		347001B01	mf 09-08-06

SPACEPOD DOOR LH



D350600-241

Dart Aerospace Ltd.

Date: Tuesday, 07/04/2009 10:27:01 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACEPOD DOOR LH		
Job Number	: 47001B			Part Number	: D31863	
Estimate Number	: 12635			Drawing Number	: D3186 REV.D	
P.O. Number	:			Project Number	: N/A	
This Issue	: 07/04/2009		S.O. No. :	Drawing Revision	: D	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	Due Date	: 10/05/2009	
Previous Run	: 45711B			Qty:	1 Um: Each	
Written By	:					
Checked & Approved By	: <u>JUL 09.04.07</u>					
Comment	: Est Rev:A New Issue 07-01-11 EC est rev B rev D dwg 07.03.07 ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	47001B01	SPACEPOD DOOR LH	/
Comment: Sub-Component SPACEPOD DOOR LH 1 x D3186-1M Batch _____			
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	/
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)			
3.0	QC5	INSPECT WORK TO CURRENT STEP	/
Comment: INSPECT WORK TO CURRENT STEP			
4.0	PACKAGING 1	PACKAGING RESOURCE #1	/
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____			
5.0	QC21	FINAL INSPECTION/W/O RELEASE	/
Comment: FINAL INSPECTION/W/O RELEASE			

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

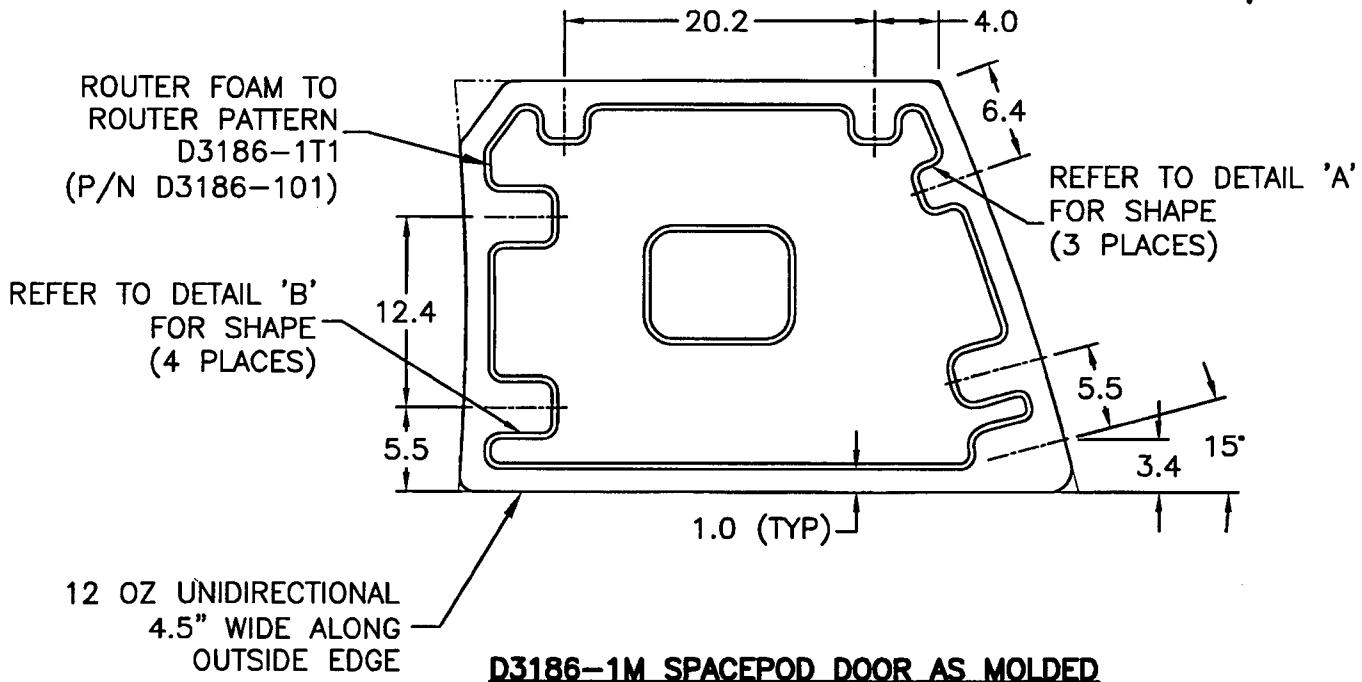
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>CH</i>	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP
9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

A	03.03.27	NEW ISSUE
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS

RELEASED07.02.27 *CH***NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECCELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

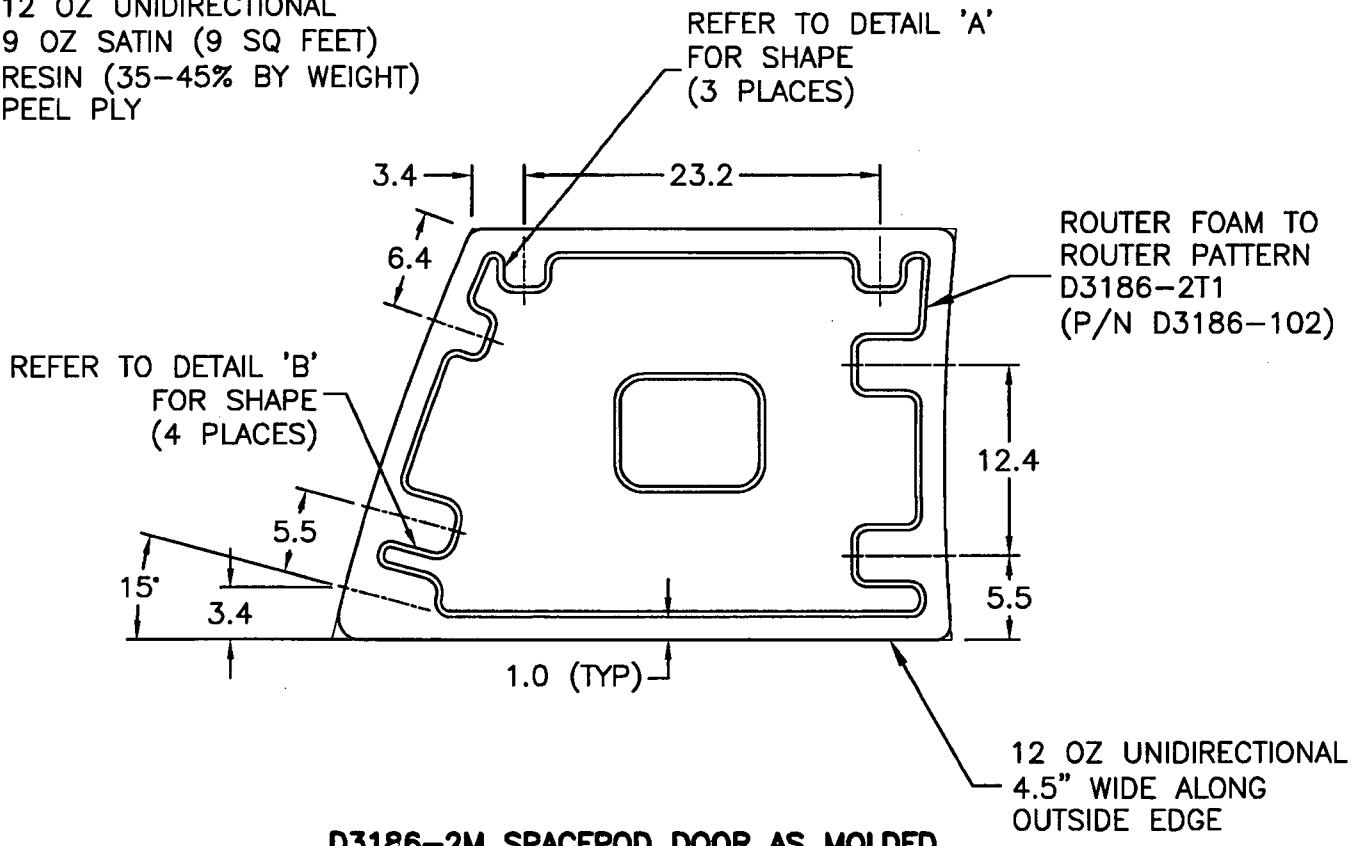
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SOLICITATION FOR TENT
NO. *47001B*

DART

DESIGN DS	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>HL</i>	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED07.02.27 *CE*NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECCELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WEARER'S NOTICE
NO. 47001B

DART

DESIGN DS	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>TH</i>	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

20.25 4.70

1.80

5.50

RELEASED

07.02.27 *CE*

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(3 PLACES)

5.50

3.46

15°

0.98 (TYP)

D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

REFER TO DETAIL 'C'
FOR HOLE DETAILS

3.59

1.80

5.85

1.41

REFER TO DETAIL 'E'
FOR HOLE DETAILS
(2 SETS)

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)

12.45

5.50

0.98 (TYP)

1.24 2.78 19°
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 4700(B)

D3186-3 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

NOTES:

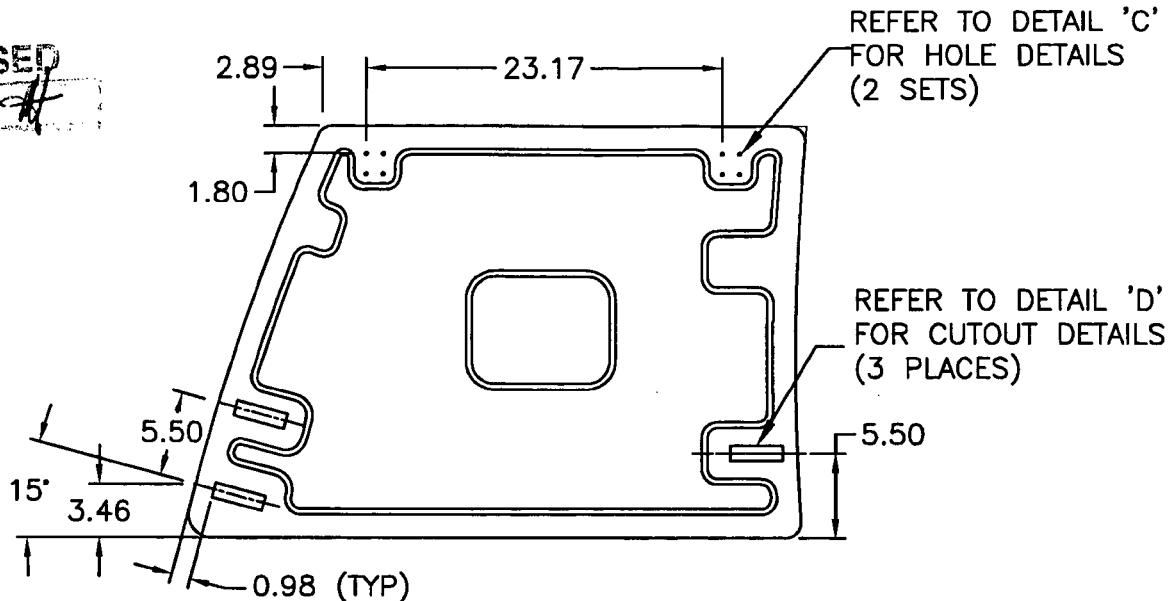
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2003 by DART AEROSPACE LTD

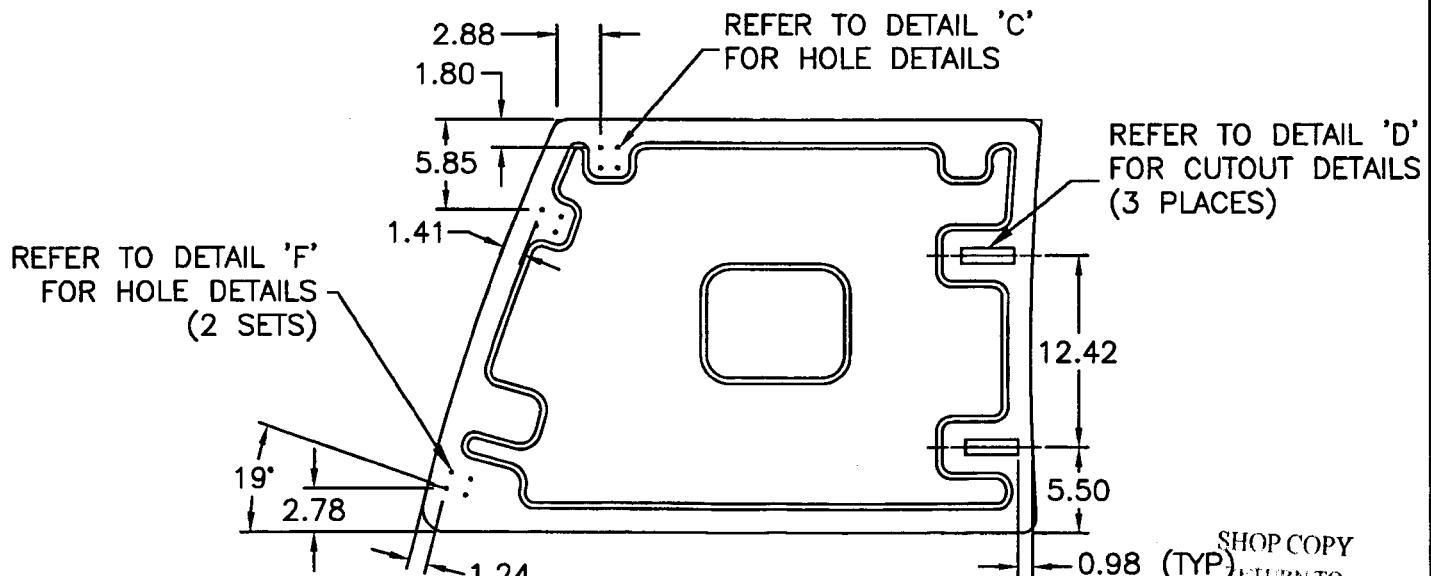
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN DS	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>BS</i>	APPROVED <i>MM</i>	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED07-02-27 *MM*

D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

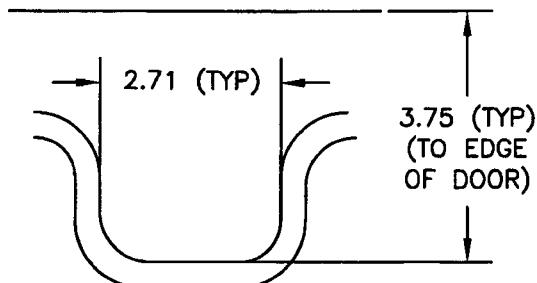
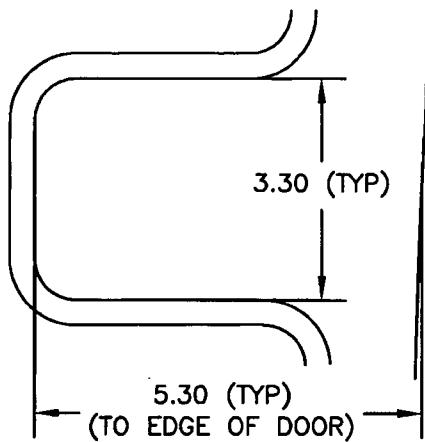
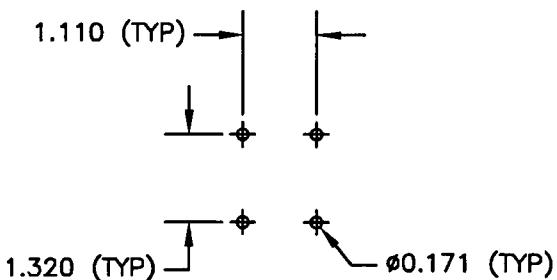
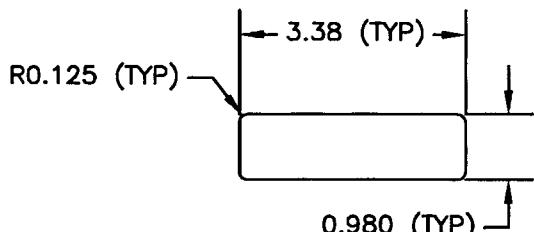
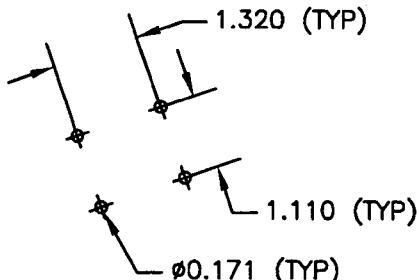
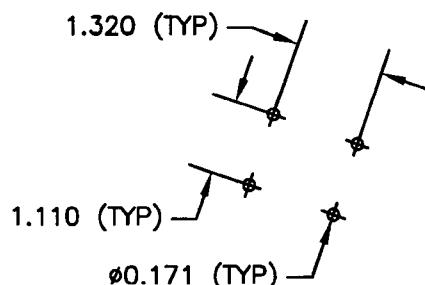


NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN DS	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>CH</i>	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**DETAIL A****DETAIL B****RELEASED**07.02.27 *CH***DETAIL C**NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR**DETAIL D****DETAIL E****DETAIL F**

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

W.D. 100-1000-0000

V.G. 100-1000-0000

NO. *4700B***NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.